

Work Order ID 128276

Tuesday, January 13, 2015 1:40:18 PM

128276

Page 1

Item ID: D4436-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Inboard Bracket Assembly

Start Date: 1/13/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLS Date: 1501-14 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4436	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4436-3 as per Dwg								
6061-040	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

6 DC 15/01/266 DC 15/01/26

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Item ID: D4436-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Inboard Bracket Assembly
 Start Date: 1/13/2015 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									JAN 26 2015
130	Bend as per dwg	0.00							
130					DAS 30 9-89				15/01/20
Brake NC	Memo	0.00							
Brake NC									
140		0.00							
140									15/01/20 DAS 36 9-89
Small Fab	Memo	0.00							
Small Fab	1- Transfer drill holes as per dwg.								
	2-C"SINK AS PER DWG								
	3-TRANSFER 0.129 HOLES THRU (2 PLACES)								

6-FF

JAN 29 2015

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Item ID: D4436-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Inboard Bracket Assembly
 Start Date: 1/13/2015 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>6</u>			DAE 38 9-89 JAN 29 2015
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							15-2-6 <i>[Signature]</i>
170 *170* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				<u>6</u>			DAE 38 9-89 FEB 09 2015

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Item ID: D4436-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Inboard Bracket Assembly
 Start Date: 1/13/2015 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180						6X			15/02/09 DAS 36 9-89
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg, do not install grommets and rubber seal.								
185	QC5- Inspect part completeness to step on W/O	0.00							
185									DAS 38 9-89
QC	Memo	0.00							
Quality Control									FEB 09 2015
190	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
190									
Powdercoat	Memo	0.00							
Powder Coating									

START: 3:20
 OVEN: 320°
 FINISH: 3:48

6 0 15-2-9. 0238

Page 5

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Stop *NS2*

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Quality Control

Small Fab

Install rubber seals and grommets, as per dwg

DAS
28

9-89

FEB 10 2015

0.00

QC

Memo

Quality Control

DAS
38
9-89

FEB 11 2015

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Item ID: D4436-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Inboard Bracket Assembly
Start Date: 1/13/2015 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/20/2015 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>57620</u>	0.00							
210									
Packaging	Memo	0.00				6X	DAS 28 9-89	FEB 11 2015	
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MLJ 1502-11

(Handwritten signature/initials)

Tuesday, January 13, 2015 1:40:20 PM

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D4436-045

Required Date: 1/20/2015

Required Qty: 5.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB
11.12.22 per PA2 EC verified by:JLM IPP REV:C 12.01.24
PER DWG REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS35489-19		Purchased	No			202	Each	321.0000	1	16			
MS35489-19 Grommet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				34					
				121091				34		6			
				ST274				287					
				121091				287					
M6061T6S.040		Purchased	No			100	sf	64.7501	0.689	4			
M6061T6S 040 6061-T6 .040 Sheet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				64.7501					
				m130312				32		6.7291			
				m130585				32.7501					
D4441-1		Manufactured	No			202	f	654.5000	0.31	2			
D4441-1 Rubber Seal													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				418					
				120932				418		2.4			
				ST422				236.5					
				120932				236.5					

Picklist Print

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Work Order ID: 128276

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Parent Item: D4436-045

D4436-045

Parent Item Name: Aft Inboard Bracket Assembly

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 5.00

Required Qty: 5.00

D4441-1 Manufactured No

654.5000

D4441-1

Rubber Seal

**

DAS
28
9-89

FEB 10 2015

Location

Loc Qty

Loc Code

ST407

418

120932

418

ST422

236.5

120932

236.5

cut qty 1 to 10.00"

MS20426AD3-2

Purchased

No

180

Each

18,153.00

4

20

**

DAS
36
9-89

Location

Loc Qty

Loc Code

Mezz

18153

1173

8873

13276

9280

MS20470AD4-3

Purchased

No

180

Each

2,373.000

2

10

**

DAS
36
9-89

MS20470AD4-3

Rivet - Universal Head

Location

Loc Qty

Loc Code

GA

1129

2193

1129

ST310

1244

2193

1244

MS21075L08

Purchased

No

180

Each

172.0000

2

10

**

DAS
36
9-89

MS21075L08

ANCHOR NUT

L08 N

Location

Loc Qty

Loc Code

ST300

172

M128635

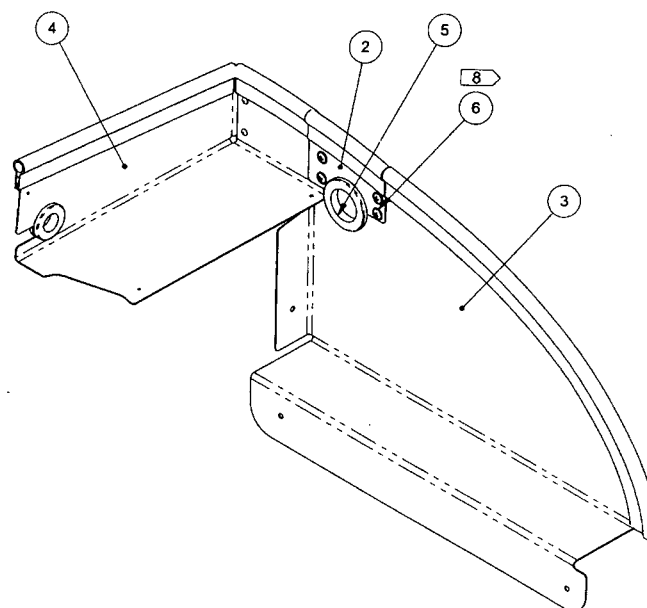
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Shop Packet Print

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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW



D4436-041 AFT BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

128276 MCL
1501-14

RELEASED
11 2012-01-23
MP

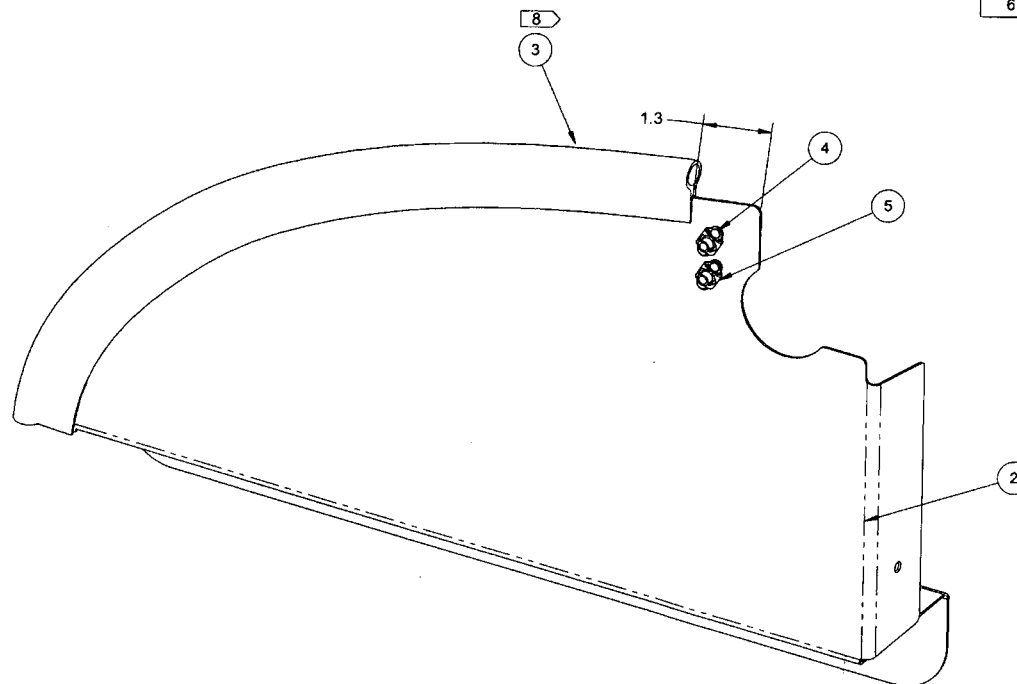
A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	12.01.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D4436
SHEET 1 OF 7
TITLE SCALE
COVER ASSEMBLY NTS

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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	MS20426AD3-2	RIVET
5	2	MS21075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE



D4436-043 AFT OUTBOARD BRACKET ASSEMBLY

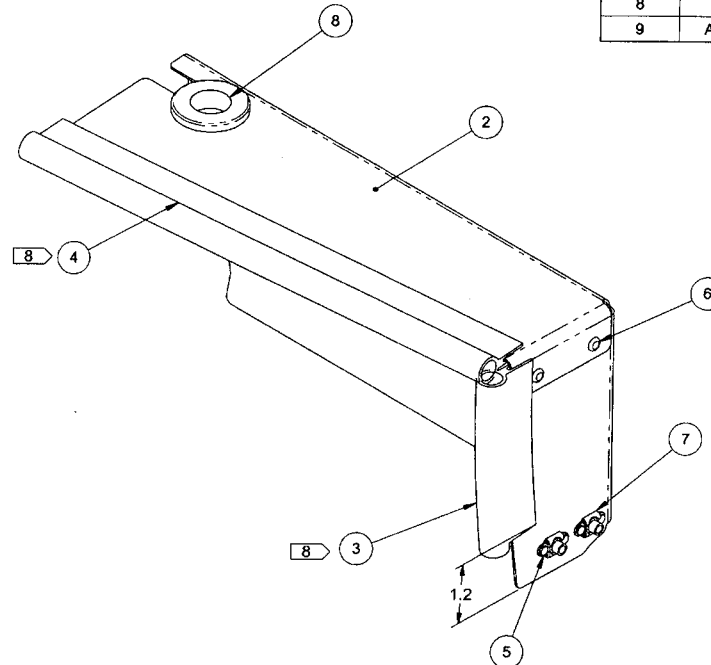
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	TITLE COVER ASSEMBLY	SHEET 2 OF 7
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DE APPR.	<i>[Signature]</i>	DATE 12.01.17	

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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-038	RUBBER SEAL
4	1	D4441-1-100	RUBBER SEAL
5	4	MS20426AD3-2	RIVET
6	2	MS20470AD4-3	RIVET
7	2	MS21075L08	NUT PLATE
8	1	MS35489-19	GROMMET
9	A/R	3M 1300/1300L	ADHESIVE



D4436-045 AFT INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3 MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE, ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL. IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM-BUCKLING

RELEASED
2012-01-23
MAP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
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MFG. APPR.	RF	TITLE COVER ASSEMBLY	SHEET 3 OF 7
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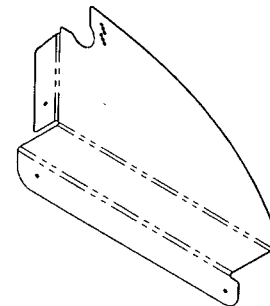
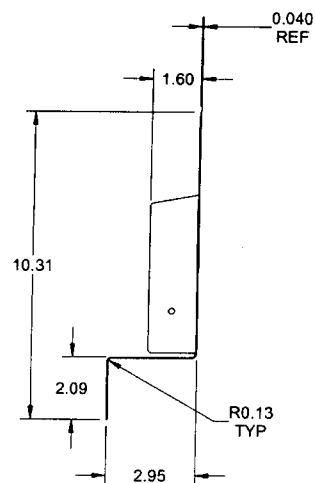
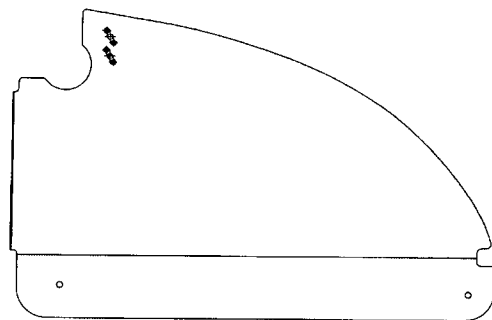
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D

C

B

A

**D4436-1 BRACKET**

RELEASE
2012-07-23

NOTES:

- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO. D4436	REV. A
MFG. APPR.	<i>[Signature]</i>		SHEET 4 OF 7
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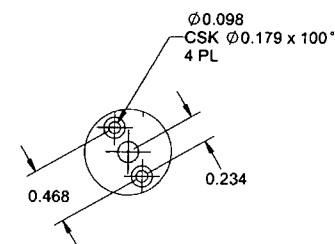
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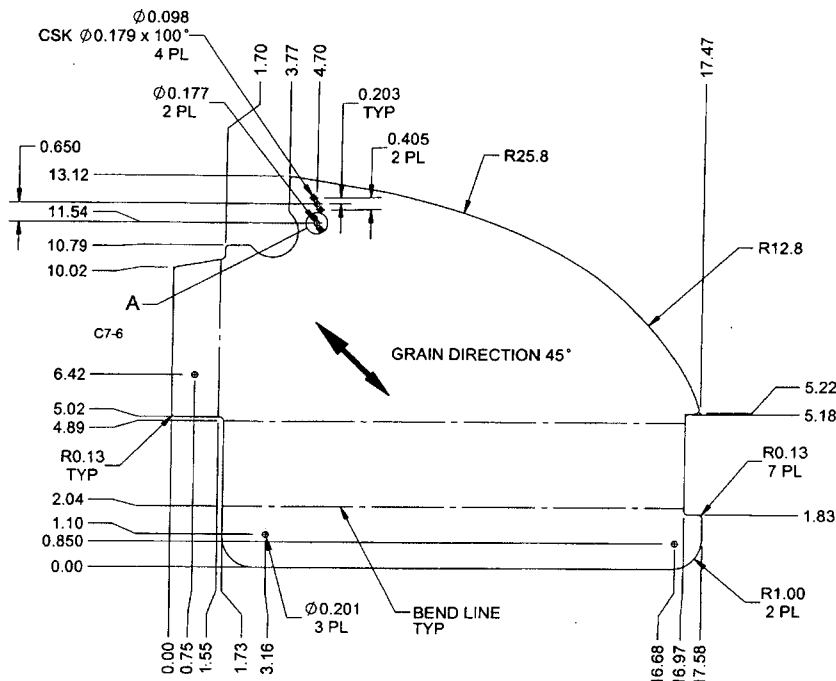
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1

A



DETAIL A C6-6
SCALE 4X, TYP



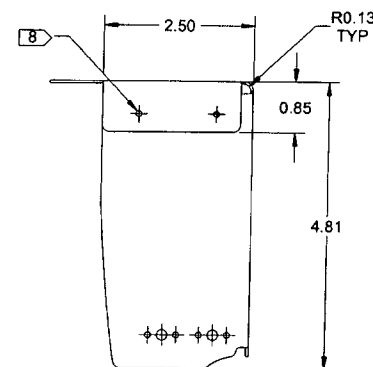
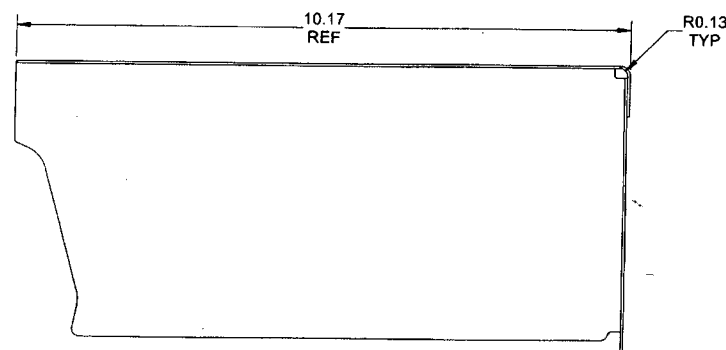
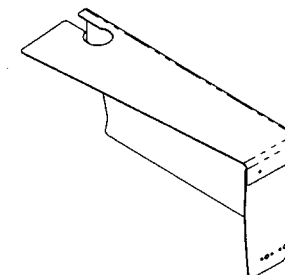
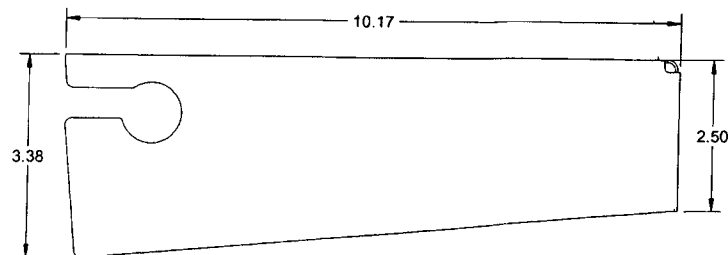
D4436-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

RELEASED
2012-07-23

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CHECKED	RF	DRAWING NO. D4436	REV. A
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D4436-3 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLES THRU 2 PLACES

RELEASE
2012-01-23

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4436	REV. A
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